

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 1006-02
 Resolution: Accepted Disposition: use as is QA: N/C Closed: AS Date: 10/06/02

NCR: <u>58251</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-5-12</u>	<u>100</u>	<u>DIMENSION $\sqrt{}$ IS OVER TOLERANCE .005"</u> <u>RC offset is too high</u> <u>→ LOA</u>	<u>AS</u> <u>10.05.12</u> <u>GS/lyz</u>	<u>Acceptable</u>	<u>AS</u> <u>10-5-11</u>	<u>S</u> <u>10/5/12</u>	<u>AS</u> <u>10.05.12</u> <u>GS/lyz</u>	<u>S</u> <u>10/5/12</u>

NOTE: Date & initial all entries

Work Order ID 58251

May 3, 2010 8:18:42 AM



Page 2

Item ID: D2573

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft Out 205

Stop



Start Date: 03/05/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/05/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

cm 10/05/18

8

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

jd 10/05/16

7

0

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 114207

=> jd 10/05/20

8

0

START TIME:

1:30pm FINISH TIME:

1:00pm

OVEN TEMPERATURE:

320°F

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58251

May 3, 2010 8:18:42 AM



Page 3

Item ID: D2573

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft Out 205

Stop



Start Date: 03/05/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/05/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8	BL	10-5-20	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>434</u> Memo	0.00 0.00					10-5-20	(82) J	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						10/05/21 J	
								BS 10-5-21 (8)	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 3, 2010 8:18:47 AM

Page 1

Work Order ID: 58251



Parent Item: D2573



Parent Item Name: Saddle, Aft Out 205

Start Date: 03/05/2010

Required Date: 10/05/2010

Comments: IPP: I As Per RevE 06-01-27 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	26.0000	1			



Saddle Billet



Location

Loc Qty

Loc Code

MAT42

26

46412

26

10.5.12

x4

4.0

B.A 10/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 58251
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.002	8.000		
F	0.490	0.510		.500	.500	.500	0.501		
G	0.257	0.262		.259	.259	.259	0.259		
H	0.375	0.380		.375	.375	.375	0.377		
I	0.490	0.510		.504	.504	.504	0.503		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		.568	.568	.568	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	0.124		
Q	0.115	0.135		.125	.125	.125	0.135		
R	0.240	0.260		.250	.250	.250	0.250		
S	0.115	0.135		.134	.134	.134	0.128		
T	0.178	0.198		.188	.188	.188	0.188		
U	3.210	3.250		3.233	3.233	3.233	3.230		
V	0.230	0.250		.245	.245	.245	0.240		
W	0.115	0.135		.140	.145	.145	0.127		
X	0.308	0.313		.310	.310	.310	0.310		
Y	0.760	0.765		.760	.760	.760	0.760		
Z	0.352	0.372		.360	.360	.360	0.366		
AA	0.470	0.530		.480	.480	.480	0.500		
AB	0.615	0.635		.633	.633	.633	0.622		
AC	0.053	0.073		.065	.065	.065	0.063		
AD	0.240	0.260		.250	.250	.250	0.246		
AE	1.500	1.520		1.510	1.511	1.510	1.513		
AF	0.115	0.135		.120	.120	.120	0.135		
AG	0.240	0.280		.243	.243	.243	0.280		
AH	0.240	0.260		.253	.253	.253	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.0032		
AJ	0.023	0.043		.033	.033	.033	0.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	10.5.12

Audited by:	<i>[Signature]</i>
Date:	10/05/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58251
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
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A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.503	0.505	0.502	0.504		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.503	0.503	0.503	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.127	0.129	0.129	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.240	0.240	0.240		
W	0.115	0.135		0.128	0.127	0.128	0.128		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.366	0.365	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.246	0.246		
AE	1.500	1.520		1.5138	1.5134	1.5138	1.5122		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.249	0.249	0.249	0.249		
AI	2.000	2.020		2.002	2.002	2.0001	2.0012		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									






Measured by:	K.A
Date:	10/05/13

Audited by:	Amf
Date:	10/10/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05.12.06 *ff*

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALDINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	REV. 1000E	
DS	PH	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2573	SHEET 1 OF 1
DATE	TITLE		SCALE
05.07.13	OUTER AFT SADDLE		2:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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